

23

Date: Wednesday, 5/16/2007 8:13:32 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
 Job Number : 32377
 Estimate Number : 10831
 P.O. Number : N/A Part Number : D29321
 This Issue : 5/16/2007 S.O. No. : N/A Drawing Number : D2932 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 32021 Material : N/A
 Due Date : 6/6/2007 Qty: 18 Um: Each
 Written By :
 Checked & Approved By : 07.05.16
 Comment : Est: B 06.06.26 New DWG rev, (mpp 2069) EC
 Est Rev:C As per Rev C 07-03-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock:

7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length

Batch No: B 25347

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr & TUMBLE

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 32377

Part Number: D29321

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07/06/09

8

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

07-06-11

(8)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

powdercoat white
per QSI 805

M 104 H4

BR/M/07-06-22

(7/8)

8.0

QC12

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

SL

07/06/22

(7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 427

U

7/6/22

59

(7)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/22

Job Completion



U 07-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-15	1	Split to send 1 to outside supplier for packing	U	07-06-15	1	U	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32377
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.115"	.107	.108	.108		
B	0.100	0.140		0.115"	.107	.107	.107		
C	0.100	0.140		0.117"	.116	.115	.117		
D	0.210	0.230		0.222"	.219	.220	.220		
E	1.245	1.255		1.251"	1.250	1.250	1.250		
F	1.245	1.255		1.250"	1.250	1.250	1.250		
G	2.495	2.505		2.501"	2.500	2.500	2.499		
H	0.510	0.515		0.511"	0.511	0.511	0.511		
I	1.572	1.582		1.579"	1.577	1.577	1.577		
J	2.495	2.505		2.501"	2.500	2.500	2.500		
K	0.257	0.262		0.258"	.259	.259	.259		
L	0.312	0.317		0.313"	.315	.315	.315		
M	0.235	0.240		0.239"	0.239	0.239	0.239		
N	0.100	0.140		.114"	.117	.119	.117		
O	0.540	0.560		.547"	.550	.550	.550		
P	0.490	0.510		.500"	.499	.500	.499		
Q	3.715	3.725		3.722"	3.719	3.719	3.718		
R	2.470	2.510		2.495"	2.495	2.495	2.495		
S	0.240	0.270		0.250"	.243	.242	.246		
T	0.100	0.180		0.135"	.140	.140	.140		
U	1.625	1.635		1.632"	1.630	1.629	1.630		
V	1.362	1.372		1.368"	1.367	1.366	1.367		
W	0.316	0.321		0.319"	.320	.320	.320		
X	1.125	1.145		1.135"	1.137"	1.140"	1.136		
Y	1.565	1.585		1.575"	1.576"	1.580"	1.573		
Z	0.178	0.198		0.188"	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.F.	Audited by: gml
Date: 07/05/20	Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 32377
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.110	.109	.109	.113		
B	0.100	0.140		.110	.107	.109	.112		
C	0.100	0.140		.117	.117	.115	.120		
D	0.210	0.230		.219	.220	.220	.221		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.499	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.499	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		.116	.116	.118	.117		
O	0.540	0.560		.549	.550	.550	.549		
P	0.490	0.510		.499	.500	.501	.500		
Q	3.715	3.725		3.719	3.719	3.719	3.719		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.248	.246	.247	.249		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.133	1.135	1.137	1.134		
Y	1.565	1.585		1.571	1.572	1.574	1.570		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L. / E	Audited by: J.M.
Date: 07/05/22 / 07/06/07	Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32377
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140							
B	0.100	0.140							
C	0.100	0.140							
D	0.210	0.230							
E	1.245	1.255							
F	1.245	1.255							
G	2.495	2.505							
H	0.510	0.515							
I	1.572	1.582							
J	2.495	2.505							
K	0.257	0.262							
L	0.312	0.317							
M	0.235	0.240							
N	0.100	0.140							
O	0.540	0.560							
P	0.490	0.510							
Q	3.715	3.725							
R	2.470	2.510							
S	0.240	0.270							
T	0.100	0.180							
U	1.625	1.635							
V	1.362	1.372							
W	0.316	0.321							
X	1.125	1.145							
Y	1.565	1.585							
Z	0.178	0.198							
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
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DART AEROSPACE LTD	Work Order: 32377
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Inspection Dwg: D2932 Rev. C	Page 1 of 1

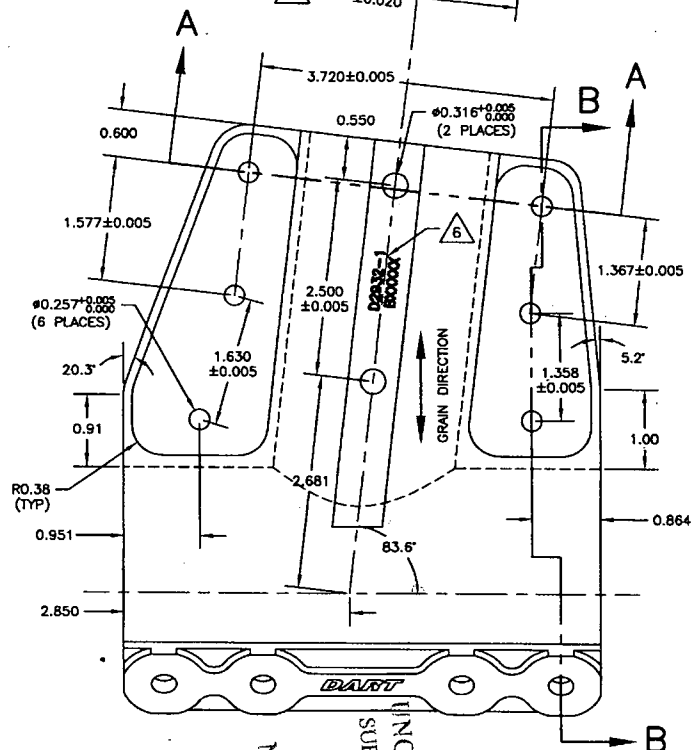
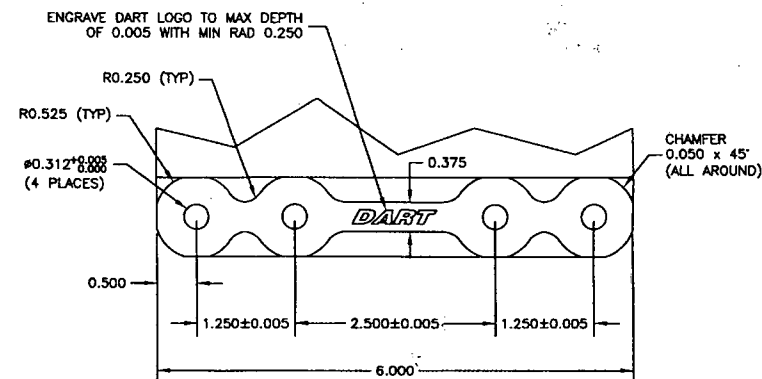
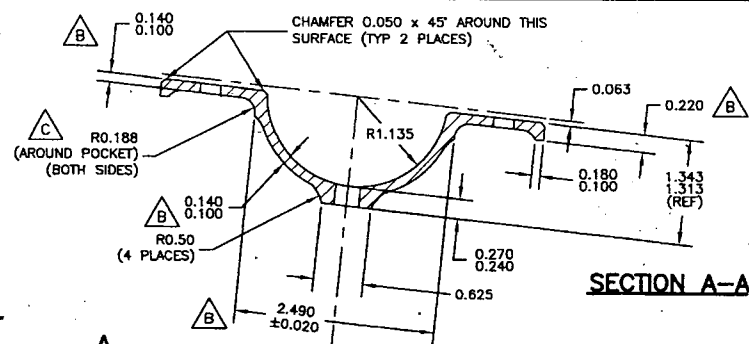
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D	0.210	0.230							
E	1.245	1.255							
F	1.245	1.255							
G	2.495	2.505							
H	0.510	0.515							
I	1.572	1.582							
J	2.495	2.505							
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L	0.312	0.317							
M	0.235	0.240							
N	0.100	0.140							
O	0.540	0.560							
P	0.490	0.510							
Q	3.715	3.725							
R	2.470	2.510							
S	0.240	0.270							
T	0.100	0.180							
U	1.625	1.635							
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X	1.125	1.145							
Y	1.565	1.585							
Z	0.178	0.198							
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

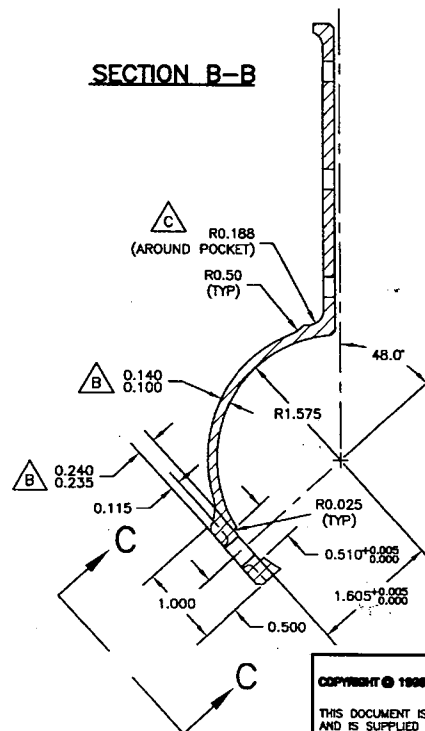
Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION B-B



D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	BY	DRAWN BY
CHECKED	BY	APPROVED BY
DATE	06.11.09	TITLE
		SADDLE OUTSIDE

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BOLLEVILLE, LA

DRAWING NO. D2932
REV. C SHEET 1 OF 1

SCALE
2:3

RELEASED
07-02-12

NO. 32377
WORK ORDER
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